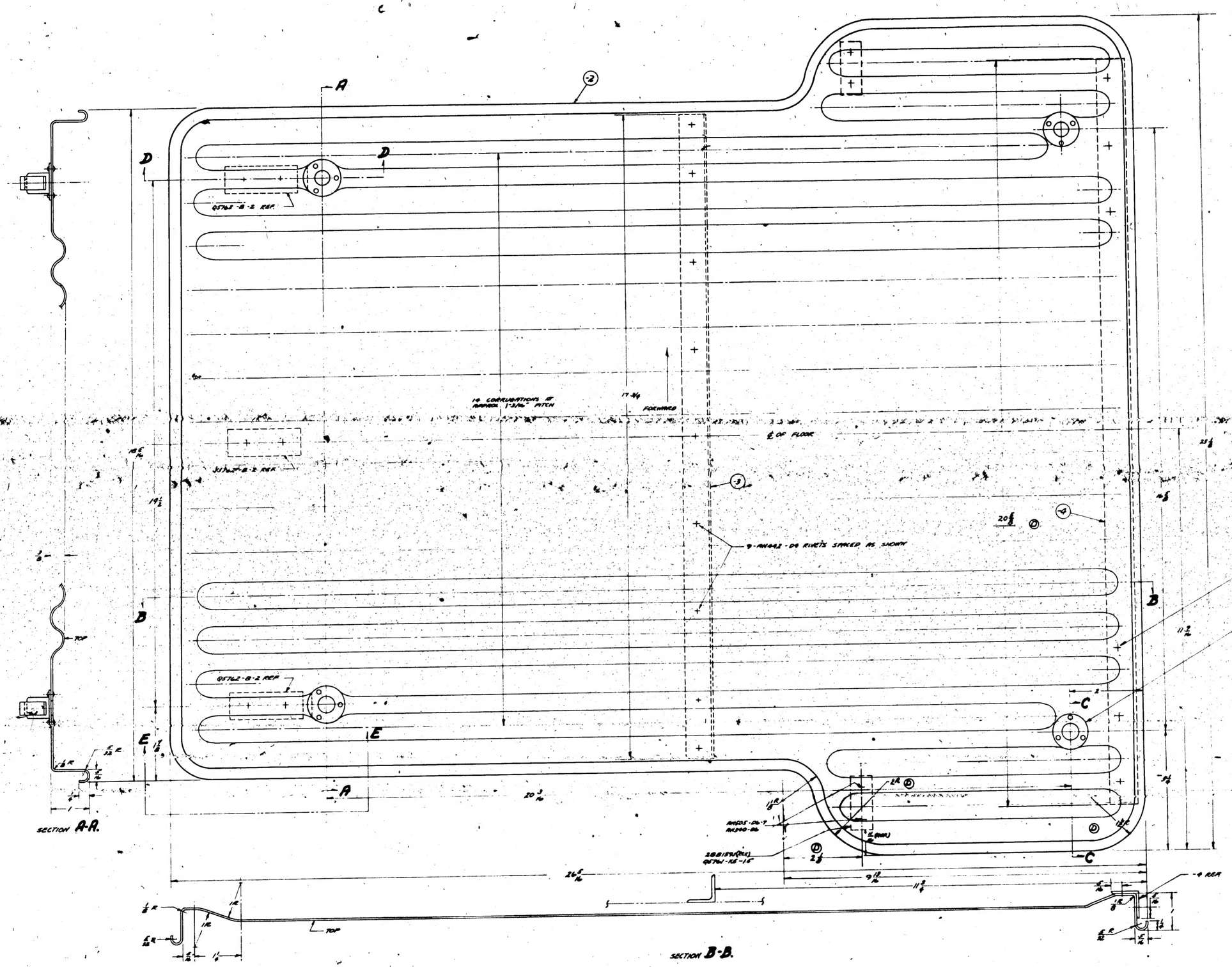
SUPPLIES & EQUIPMENT CLASSIFICATION		
LET	ALTERATIONS	DATE BY
C	TRANSD UP TO DATE	6-23-38
D	20 1/8 WAS 21 1/8 & 1/8 WAS 1/4	
	2 R WAS 1/8 R & 4 R WAS 1/8	11-8-40
E	REPAIR DRAWN FROM B.P. 1	
	PAGE OF DWG - NOTE ADDED	7-3-41
F	NOTE "MATERIAL PER B-3 ------	
	Y-2-A278 T 20 3/4" WAS	
	3/4 x 3/16 x 1/16 ANGLE DIE	
	K5401, SPEC. QQ-A-354 COND. T	
	(0.197) - 3 - 8. WT. CHG. REQ.	8-6-41
G	ON FACE TO MAT'L. NOTE FOR	
	-8 ADDED" OR WAS 1.41 1/16 AL AL	
	EXTR. SPEC QQ-A-354-T." FOR -6	
	ADDED" OR K5401 x 2.0 3/4 AL. AL.	
	EXTR. SPEC QQ-A-354-T" NO WT CHG REQ	

E.O. 28067
E.O. A6632
E.O. # B18753



AN442-D4 RIVETS. SPACE APPROX. AT EVERY SECOND CORRUGATION.

ATTACH STANLEY FASTENERS IN POSITION AS SHOWN. MAINTAIN FLAT SPACE OF 1" DIA. AT EACH FASTENER.

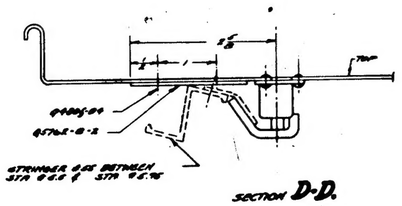
SPEC. 47A10 COND. B. ALUMINUM ALLOY SHEET .040(2S30) -Z
HEAT TREAT PER SPEC. 3.655 (2S-ST.)

MATERIAL FOR -3: Y-2-A278 T 20 1/4 OR K5401 x 17 1/8, AL. AL. EXTR., SPEC. QQ-A-354-T
MATERIAL FOR -4: Y-2-A278 T x 20 1/4 OR K5401 x 20 1/4, AL. AL. EXTR., SPEC. QQ-A-354-T

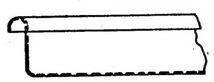
Q5762-B-2 [illegible] CEMENT AND Q5560-8 RIVETS. WEBBING MUST BE WATERPROOF.

NOTE:
ANCHOR NUTS & STANLEY FASTENERS ARE TO BE FINISHED AS PER SPEC. 27-28-006 #102.28.
SPEC. 27-28-006 #102.28: ANCHOR NUTS (STEEL) & STANLEY FASTENERS. APPLY (1) BRUSH COAT OF ZINC CHROMATE PRIMER TO THE CONTACTING SURFACE OF THE NUT OR FASTENER. APPLY (2) COATS OF PRIMER TO THE SUPPORTING SURFACE. ASSEMBLE WITH ZINC CHROMATE PASTE IN THE JOINT SUCH THAT EXCESS MATERIAL IS SQUEEZED OUT AT ALL BOUNDARIES. REMOVE THE EXCESS MATERIAL IN SUCH A MANNER AS TO FORM A FILLET.

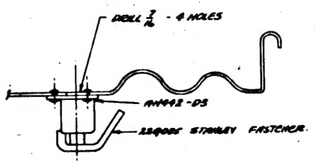
	P. GREEN PRIME
FINISH	
Z	ZINC TREATED
P	PAINT FINISH
AP	ALUMINIZED PAINT
C	CHROMATE PLATE



SECTION D-D.



VIEW E-E.



SECTION C-C.

FINISH Z-P BEFORE ATTACHING FASTENERS
2B8038C P 2B8038 PRIOR TO ATTACHING.
3 ea. COMPLETE ASSEMBLY

NOTE:-
2B83774 REPLACES 2B82774
FOR PBY-6 & PBY-3 "A" SPARES

| | | |